

Date: Wednesday, 03/06/2009 10:48:43 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
Job Number	: 48352		Part Number	: D2571	
Estimate Number	: 10530		Drawing Number	: D2571 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 03/06/2009	S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	: MACHINED PARTS		
Previous Run	: 47564		Due Date	: 30/06/2009	Qty: <i>12</i>
Written By	:		Um:	Each	
Checked & Approved By	: <u>JL 09.06.09</u>				
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <i>46412</i></p> <p><i>JL 09/06/19</i></p>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <i>48352</i> Double check by: <i>JK</i></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.</p> <p><i>JL/H.A 09/06/20</i></p>			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<p>Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572</p> <p><i>JL/H.A 09/06/20</i></p>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p><i>JL/H.A 09/06/20</i></p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:43 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

OK 09/06/22

(12)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(112)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MD 09/06/22

7.0 POWDER COATING

POWDER COATING



M111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 12:00pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:30pm

12:00pm 09-06-22 (X12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AM 09-06-23 (12)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST433

12:00pm 09/06/23 (12)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 (12)

Job Completion



12:00pm 09/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	48352
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 3	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.950	1.750		
E	7.990	8.010		8.001	8.001	8.002	8.002		
F	0.490	0.510		.500	0.506	0.503	0.503		
G	0.257	0.262		.259	0.259	0.259	0.259		
H	0.375	0.380		.376	0.376	0.377	0.377		
I	0.490	0.510		.500	0.500	0.500	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	0.569	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	0.126	0.126	0.126		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.250	0.251	0.250	0.251		
S	0.115	0.135		.126	0.122	0.123	0.123		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	0.238	0.240	0.235		
W	0.115	0.135		.121	0.120	0.121	0.122		
X	0.308	0.313		.311	0.310	0.310	0.310		
Y	0.760	0.765		.760	0.760	0.760	0.760		
Z	0.352	0.372		.365	0.365	0.365	0.366		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.615	0.626	0.625	0.623		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.248	0.248	0.247	0.248		
AE	1.375	1.395		1.388	1.389	1.388	1.397	1.3875	
AF	0.115	0.135		.130	0.130	0.130	0.130		
AG	0.240	0.280		.250	0.250	0.250	0.250		
AH	0.240	0.260		.251	0.247	0.252	0.245		
AI	2.000	2.020		2.001	2.001	2.000	2.002	2.000	
AJ	0.023	0.043		.033	0.033	0.033	0.033		

Accept/Reject

Measured by:	SL / H.A	Audited by:	CMF
Date:	09/06/20	Date:	09/06/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	CMF

DART AEROSPACE LTD				Work Order: 48352
Description: Saddle, Fwd Outboard				Part Number: D2571
Inspection Dwg: D2571 Rev. E				Page 2 of 3

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.501	0.503	0.500	0.498		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.499	0.499	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.568	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.253		
S	0.115	0.135		0.125	0.122	0.125	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.238	0.235		
W	0.115	0.135		0.122	0.123	0.121	0.120		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.357	0.367	0.366	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.624	0.628	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.248	0.248		
AE	1.375	1.395		1.3895	1.3907	1.3894	1.3906		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.247	0.245	0.248	0.249		
AI	2.000	2.020		2.0005	2.0028	2.0004	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: M. A
Date: 09/06/20

Audited by: G.M.
Date: 09/06/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2021

DART AEROSPACE LTD				Work Order: 48352
Description: Saddle, Fwd Outboard				Part Number: D2571
Inspection Dwg: D2571 Rev. E				Page 3 of 3

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	20	21	22		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.500	0.503	0.500	0.497		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.498	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.122	0.121	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.235	0.238	0.236		
W	0.115	0.135		0.120	0.120	0.120	0.120		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.367	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.623	0.622	0.621		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.248	0.247		
AE	1.375	1.395		1.3904	1.3900	1.3902	1.390		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.247	0.247	0.248	0.247		
AI	2.000	2.020		2.0023	2.0028	2.0017	2.0016		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	G. A	Audited by:	✓
Date:	09/06/21	Date:	09/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	✓ ✓

